DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-014775
Date Inspected: 13-Jun-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name:				**CWI Present:**	☐ Yes	☑ No	
Inspected CWI report:	☐ Yes	☐ No	☑ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A
Electrode to specification:	☐ Yes	☐ No	☑ N/A	**Weld Procedures Followed:**	☐ Yes	☐ No	☑ N/A
Qualified Welders:	☐ Yes	☐ No	☑ N/A	**Verified Joint Fit-up:**	☐ Yes	☐ No	☑ N/A
Approved Drawings:	☐ Yes	☐ No	☑ N/A	**Approved WPS:**	☐ Yes	☐ No	☑ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Bay 09, Deck Panel 13CW-DP3144-001

This QA inspector performed conventional Ultrasonic Testing (UT) Inspection on deck panel tack weld areas. The inspection is preliminary prior to using the phased array (PAUT) testing system to verify indications found with conventional Ultrasonic testing. QA inspector performed UT on deck panel 13CW-DP3144-001, 12 ribs, 24 welds, 184 total tack welds inspected.

Weld 001 scanned 9 locations with 1 indication.
Weld 002 scanned 9 locations with 1 indication.
Weld 003 scanned 9 locations with 2 indications.
Weld 004 scanned 9 locations with 0 indications.
Weld 005 scanned 9 locations with 1 indication.
Weld 006 scanned 9 locations with 4 indications.
Weld 007 scanned 9 locations with 3 indications.
Weld 008 scanned 9 locations with 1 indication.
Weld 229 scanned 9 locations with 2 indications.

Weld 231 scanned 9 locations with 1 indication.
Weld 230 scanned 9 locations with 2 indications.
Weld 232 scanned 9 locations with 3 indications.
Weld 233 scanned 9 locations with 2 indications.
Weld 235 scanned 9 locations with 3 indications.
Weld 234 scanned 9 locations with 1 indication.
Weld 236 scanned 9 locations with 1 indication.
Weld 237 scanned 5 locations with 0 indications.
Weld 238 scanned 5 locations with 0 indications.
Weld 239 scanned 5 locations with 0 indications.
Weld 240 scanned 5 locations with 2 indications.
Weld 241 scanned 5 locations with 0 indications.
Weld 242 scanned 5 locations with 1 indication.
Weld 243 scanned 5 locations with 2 indications.
Weld 244 scanned 5 locations with 1 indication.

OBG Bay 09, Deck Panel 13CW-DP3144-001

QA Inspector performed initial Phased Array Ultrasonic Testing (PAUT) following the guide lines of UT procedure titled “Phased Array Ultrasonic Testing for the Detection and Sizing of Suspected Planar Discontinuities (Cracks) in PJP Welds, # UT 04-0120F4 PJP Rib Weld” after conventional UT was performed on tack welded areas of the Partial Joint Penetration (PJP) welds joining u-ribs to deck plate. The deck panels examined are as follows:

DP3144-001: 10 tack weld locations found compliant and 24 tack weld location found non-compliant.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:
Only general conversation was held between QA and QC concerning this project.
Comments
This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer